

Date: Friday, 19/10/2007 2:50:25 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLOOR PROTCTOR FWD LH		
Job Number	: 35246			Part Number	: D32811		
Estimate Number	: 11227			Drawing Number	: D3281 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 19/10/2007	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: 18/10/2007	Type	: R&D THERMOFORMING	Due Date	: 25/10/2007	Qty:	45 Um: Each
Previous Run	: 35082						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A 04.07.01 New issue KJ/JLM Est. Rev B. 07.16.2007 Thermoform in house DL						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: <u>4865</u> <i>C7/10/22</i> Description: Floor Protector Fwd, LH Possible Supplier: Delastek Certificate of Conformity is required
2.0	D32811P	Floor Protector, Fwd LH
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Floor Protector Fwd, LH
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached <i>C7/10/25</i>
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins. <i>C7/10/29</i> <i>(X4)</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST266</u> <i>(X4) C7/10/30 AS/</i>

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR FWD LH

Job Number: 35246

Part Number: D32811

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



07.10.31 JF

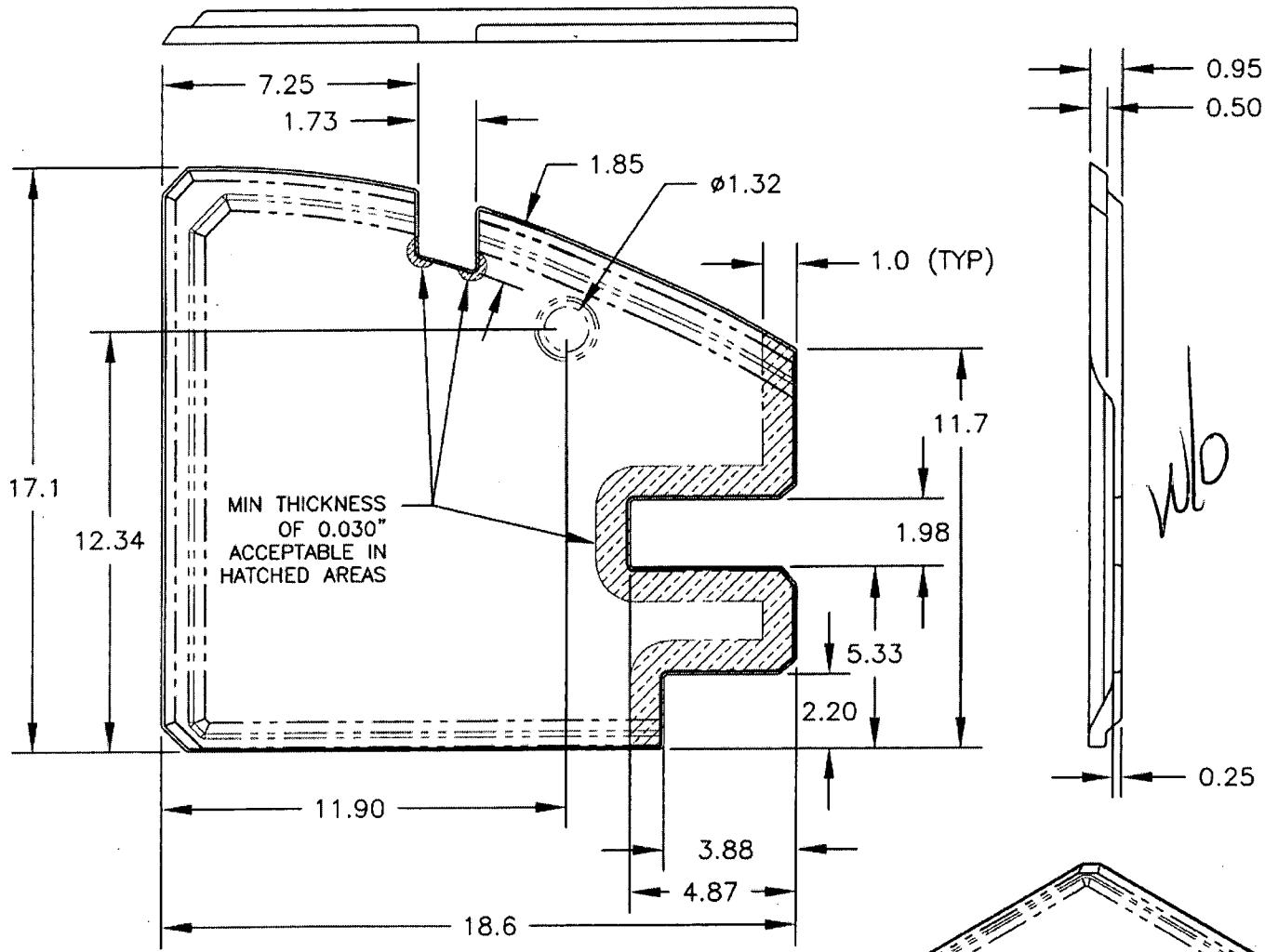
Job Completion



U 07.10.31

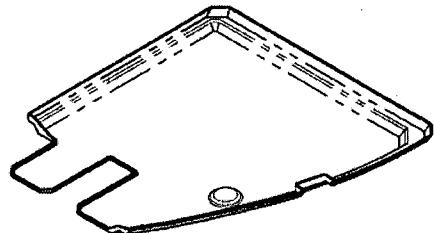
DART

DESIGN <i>UP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**
05.12.01**UNDER REVIEW**

07.10.05 LE
OK TO MANUFACTURE
AND SHIP

V6 07.10.05

**D3281-1 FLOOR PROTECTOR FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35246

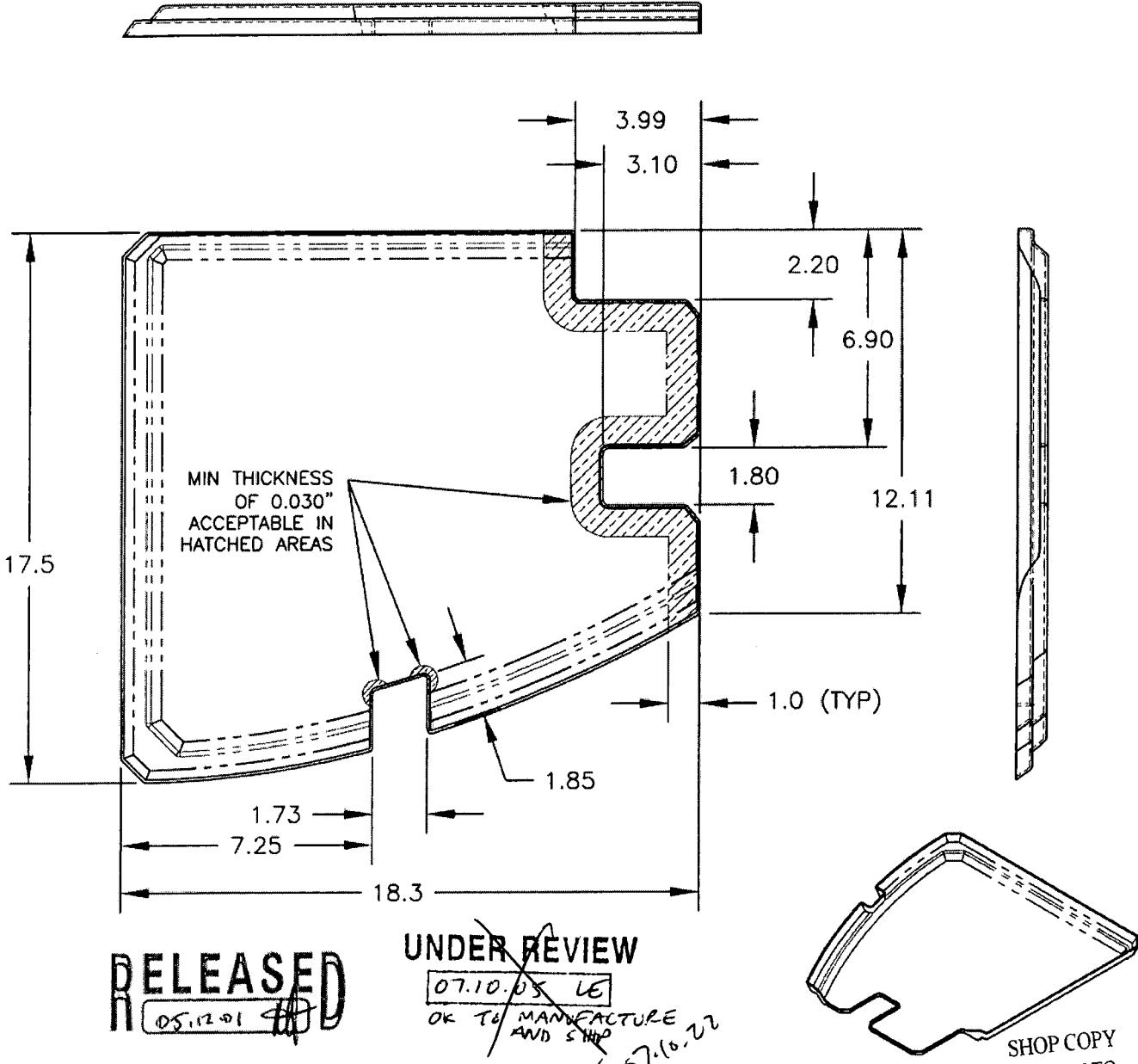
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NO.

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR	SCALE 1:5	



RELEASED
05.12.01 *[Signature]*

UNDER REVIEW

07.10.05 LE

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✓ 6/10/02



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NO. *35046*

D3281-2 FLOOR PROTECTOR FWD RH

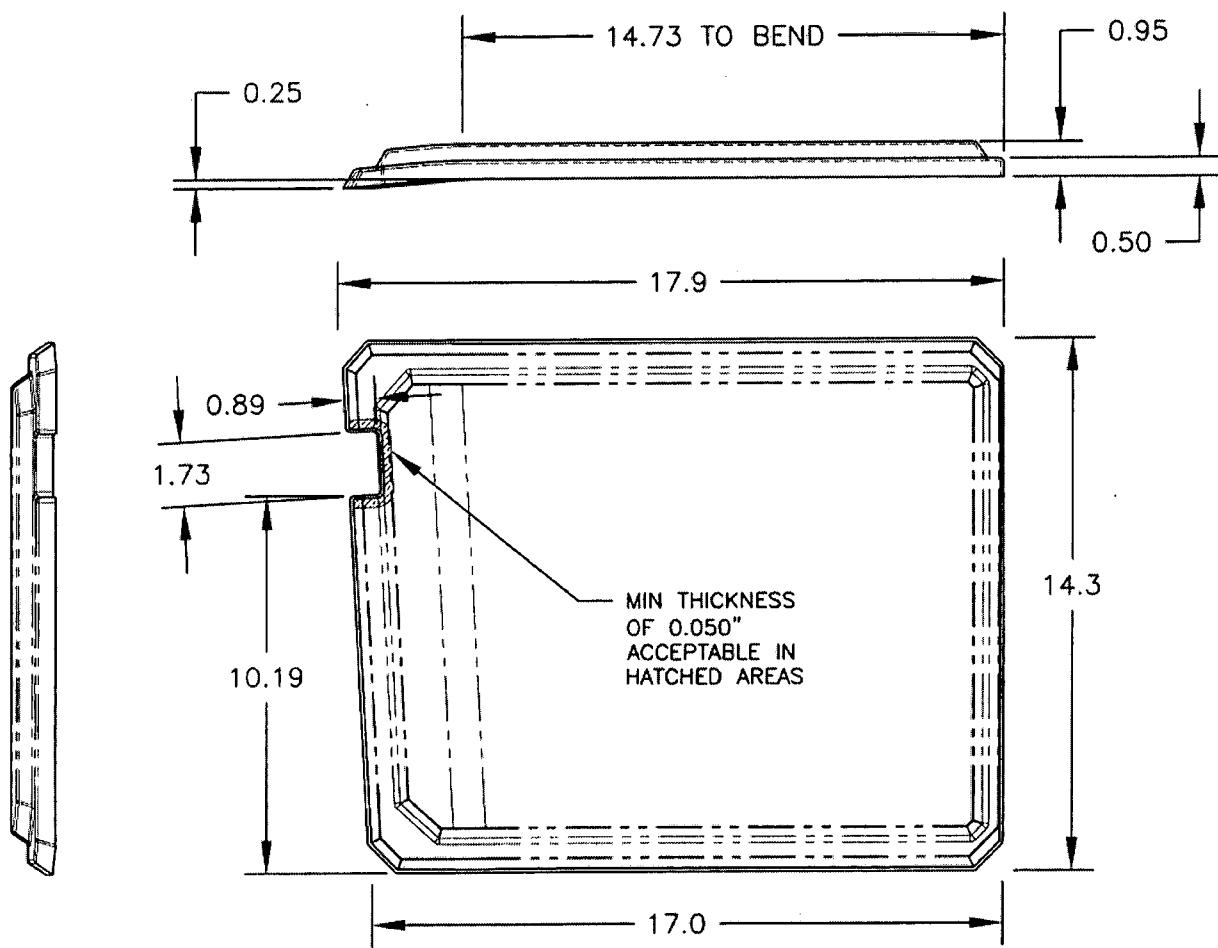
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DART

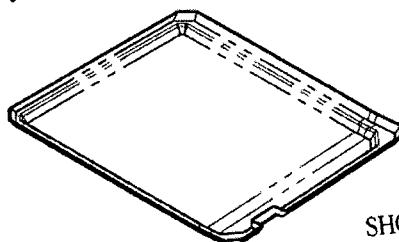
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AS</i>	APPROVED <i>AS</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**

05.12.01

UNDER REVIEW

07.10.05 LE

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AND SHIP

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WITHOUT NOTICE
WORK ORDER
NO. 35246

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
- 2) THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 3) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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Date: Mercredi, 2007-02-07 13:19:00
Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR
Numéro Job : 40952		Numéro Article : DKC134-0044
Numéro Soumission : 2383		Numéro Dessin : D3281
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2007-02-07	No. B.V. :	Révision dessin : B
Prsht Rev. : NC		Matériel : F6006
Prem. fois : -	Type :	Date Dûe : 2007-02-14
Job précédente : 40354		Qté: 20 Udl/M: UNITE
Écrit par :		
Vérifié & Approuvé par :		
Commentaires :	N° de pièce: D3281-1	



Process Sheet Rév.: 00 Création du premier

SN: B30658

Produit additionnel

à Thermoformer BV 28.02.07

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
Commentair Qty.:	0.167 UNITE(s)/Unit Total : 3.7	APL0016
	Lexan F6006 Noir N° 700 48" x 96" x .125" 1	3-5913-1
	N° de Lot:	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
		# Bon achat: 5913
2.0	SÉCHAGE/ANEAL	

Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs

SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuison: 5517

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs

TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.



Quantité: 20 Date: 13-2-06 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____

Date: Mercredi, 2007-02-07 13:19:00
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40952

Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0044

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIÈCE DART
Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs THERMOFORMAGE DES PIECES		
Faire le thermoformage du " Floor Protector " N° D3281-1 à l'aide du moule N° D3281-1T1 sur le thermoformeur 4' x 8'.		
Autocontrôle du lot de pièce thermoformées.		
Quantité: <u>20</u> Date: <u>13-2-07</u> Sceau:		
Quantité: _____ Date: _____ Sceau: _____		
5.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs TRIMAGE PLASTIQUE DART		
Faire le trimage du " Floor Protector " N° D3281-1 à l'aide du gabarit de trimage N° D3281-1T2.		
Faire l'ébavurage des pièces.		
Autocontrôle du lot de pièce trimées.		
Quantité: <u>20</u> Date: <u>23-2-07</u> Sceau:		
Quantité: _____ Date: _____ Sceau: _____		
6.0	INSPECTION 3	INSPECTION PIÈCE DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs INSPECTION PIÈCE DART		
Faire l'inspection finale des pièces selon le dessin.		
Quantité: <u>20</u> Date: <u>27/2/07</u> Sceau:		
7.0	IDENTIFICATION4	IDENTIFICATION PIÈCES DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs IDENTIFICATION PIÈCES DART		
Faire l'identification des pièces à l'aide des informations suivantes:		

Date: Mercredi, 2007-02-07 13:19:00
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 40952

Numéro Article: DKC134-0044

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-1

N° de Job: 40952

Date de fabrication: 23-02-07

Sceau d'inspection.

Quantité: 20 Date: 23-02-07 Sceau: HB

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boite en carton identifiée comme suit:

N° de pièce: D3281-1

Date de fabrication: _____

N° de job: _____

Quantité: 20 Date: 27/2/07 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice #	12223
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

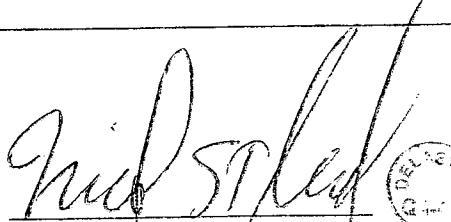
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #	
24/10/2007	22/10/2007	5510	C. LAVOIE	PO000004865		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description		
4	0	4	DKC134-0044	Floor Protector Fwd LH Part 1 N° D32811P B35246 Selon dessin D3281 Rev.: B Job: 40952		
4	0	4	DKC134-0045	Floor Protector Fwd RH Part 2 N° D32812P B35247 Selon dessin D3281 Rev.: B Job: 40953		
4	0	4	DKC134-0046	Floor Protector Aft LH Part 3 N° D32813P B35248 Selon dessin D3281 Rev.: B Job: 40954		
4	0	4	DKC134-0047	Floor Protector Aft RH Part 4 N° D32814P B35249 Selon dessin D3281 Rev.: B Job: 40957		

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: 
Nick St. Leger
Quality department

Cust.

Adm.

Quality

Ship.

Quality department

AQ-357